Work Order ID 116512

April-17-14 7:45:03 AM

116512

Item ID: D4805-5 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: End Fitting

Start Date: 4/16/14 **Start Qty:** 4.00 *4*

Required Date: 5/01/14 **Req'd Qty:** 4.00 *4*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MLS **Date:** 14-04-17 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D4805	Revision Nbr: Rev A								
100		0.00							
100									
Outsource5	**Memo**	0.00							
Outsource process - Machining	ISSUE P/O: 23800 POSSIBLE SUPPLIER:ATG C OF C IS REQUIRED								
110	QC6- Inspect dimensions to drawing	0.00							
110									
QC	**Memo**	0.00							
Quality Control									
150		0.00							
150	PURCHASING								
Purchasing	**Memo**	0.00							
Purchasing	Issue P/O: _____ LPI Per ASTM 1417 LEVEL 2 Certificate of conformaty is required								

DAS 27 8-89 14/6/25

CL 14/04/17

14/4/20 (4)

4

CL 14/06/20

N/A done@ATG

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 116512

April-17-14 7:45:03 AM

116512

Item ID: D4805-5 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: End Fitting **Stop** *NS2*

Start Date: 4/16/14 **Start Qty:** 4.00 *4*

Required Date: 5/01/14 **Req'd Qty:** 4.00 *4*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Receive & Inspect for Damage & Mat'l Certs	0.00				4X		SP 14-625	
160									
Packaging	**Memo**	0.00							
Packaging	Ensure certificate of conformity is attached								
			ST 121			4X		SP 14-625	
190	QC21- Final Inspection - Work Order Release	0.00							
190						MLJ		14-06-25	
QC	**Memo**	0.00							
Quality Control									

14-625

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

April-17-14 7:45:07 AM

Work Order ID: 116512

116512

Parent Item: D4805-5

D4805-5

Parent Item Name: End Fitting

Start Date: 4/16/14 **Required Date:** 5/01/14

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP REV:A NEW ISSUE JLM 14-01-28 VERIFIED BY:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4805-5P		Purchased	No				Each	0.0000		4			
D4805-5P									**		4/17/14	CY	
End Fitting													
M174PH-H900R1.375		Purchased	No				f	80.0000		2			
M174PH-H900R1.375									**		CY 14/04/17		
17-4 SS H900 ROUND BAR 1.375													

Location	Loc Qty	Loc Code	
MAT031	80		
111123	12		
121280	27		2
m126952	41		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

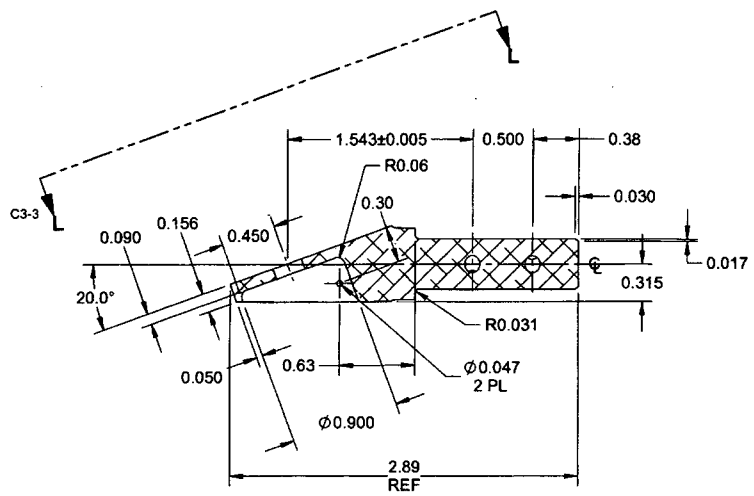
FAULT CATEGORY

Landing Gear

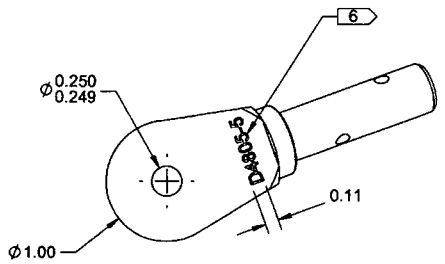
- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

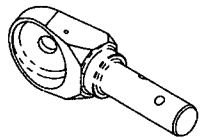
- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
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- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
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- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

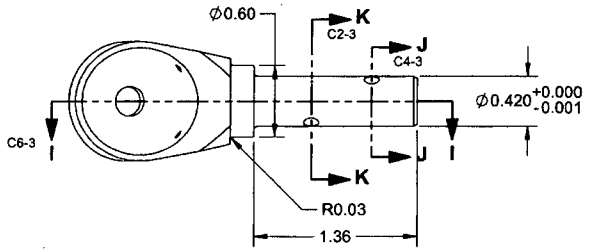


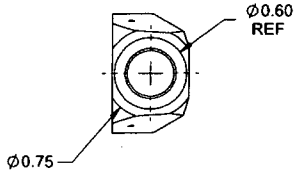
SECTION I-I B7-3

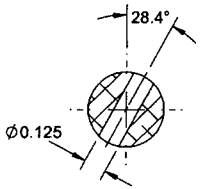


AUXILIARY VIEW L-L D8-3

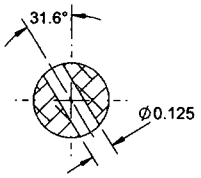








SECTION J-J B6-3



SECTION K-K B6-3

D4805-5 END FITTING

116512 MLJ
14-04-17

NOTES:
1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3.
ENGRAVE P/N USING 0.11 HIGH LETTERS TO A MAX. DEPTH OF 0.010
7) WEIGHT: 0.14 lbs
8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED

DESIGN	RF	**DART AEROSPACE LTD**
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	HS	DRAWING NO. D4805 REV. A
MFG. APPR.	JLM	SHEET 3 OF 3
APPROVED	HS	TITLE END FITTING SCALE NTS
DE APPR.	DS	
DATE	13.12.16	

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DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
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- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23860

Purchase Order Date 4/17/2014
PO Print Date 4/22/2014

Order From : VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 613-446-4544

Ship To Contact
Ship To Phone
Ship Via: VENDOR'S TRUCK
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA – (Free Carrier)

						Line Total:		**$1,160.00**
6	D4805-5P	End Fitting	5/19/2014 Yes 5/19/2014	FN	4.00 Each		$145.00	$580.00
	MACHINE AS PER DWG D4805 REV. A B116512 MATERIAL: 174PH-H900R1.375 M121280							
						Line Total:		**$580.00**
7	D4805-3P	End Fitting	5/19/2014 Yes 5/19/2014	FN	8.00 Each		$145.00	$1,160.00
	MACHINE AS PER DWG D4805 REV. A B116511 MATERIAL: 174PH-H900R1.375 M121280							
						Line Total:		**$1,160.00**
8	D4805-1P	End Fitting	5/19/2014 Yes 5/19/2014	FN	4.00 Each		$145.00	$580.00
	MACHINE AS PER DWG D4805 REV. A B116510 MATERIAL: 174PH-H900R1.375 M121280							

Note:

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544
Fax: (613) 446-4556

ATG INDUSTRIES INC.

Pack List

Number: 908154 Date: 20-Jun-14

To

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613 632-9577 Fax: 613 632-1053

Ship To

CHANTAL LAVOIE
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613 632-9577 Fax: 613 632-1053

Terms	Ship Via

Quantity	Description		
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.		
4 ea	Part: D4870-1P END FITTING, SMALL Job: 16223	PO: PO23860	Rev: A Line: 12
4 ea	Part: D4870-3P END FITTING, LARGE Job: 16224	PO: PO23860	Rev: A Line: 13
1 ea	Part: D4885-5P END FITTING Job: 16227	PO: PO23860	Rev: A Line: 17
8 ea	Part: D4808-1P ROD END Job: 16213	PO: PO23860	Rev: A Line: 2
4 ea	Part: D4805-5P END FITTING Job: 16217	PO: PO23860	Rev: A Line: 6
8 ea	Part: D4805-3P END FITTING Job: 16218	PO: PO23860	Rev: A Line: 7

DATE : 20 Jun 2014

CERTIFIED SIGNATURE: J Arotte

RECEIVER SIGNATURE : _____

CERTIFICATE OF CONFORMANCE

A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT ARE IN CONFORMANCE WITH THE REQUIREMENTS, SPECIFICATIONS, AND DRAWINGS REFERENCED IN THE ABOVE PURCHASE ORDER.

First Article Inspection Report

ATG INDUSTRIES INC.

731 Industrielle St
Rockland, Ontario K4K 1T2
Ph: 613 446-4544

Customer:	Dart Aerospace	Date:	June 20th, 2014	513
Part Number:	D4885-5P	Revision:	A	
PO Number:	PO23860	Qty:	1	FAI No.

Item	Dimension	Measurement Inspected by: Rene Tougas, Q.C.	Remarks
1	1.53	1.526	Section P-P
2	.030	.030	
3	.45	.450	
4	Ø.500	.502	
5	.017	.017	
6	.43	.431	
7	.500	.500	
8	23.8º	23.8º	
9	.08 REF	.130	
10	3.700	3.699	
11	2.296±.005	2.292	
12	R.06	✓	
13	.063	.0635	
14	.41	.415	
15	R.13 TYP	✓	
16	1.86	1.870	
17	.60	.605	
18	R.06	.063	
19	.52	.521	Auxiliary View Y-Y
20	Ø.250/.249	.2495	
22	.131	.132	
23	Note 6	✓	
24	.68	.681	
25	.11	.115	
26	.60	.600	
27	R.13	✓	
28	.80	.796	
29	.55 REF	.550	
30	R.49	.483	Auxiliary View T-T
31	.065 TYP	.066	
32	.97	.966	

First Article Inspection Report

ATG INDUSTRIES INC.

731 Industrielle St
Rockland, Ontario K4K 1T2
Ph: 613 446-4544

Customer:	**Dart Aerospace**	Date:	**June 20th, 2014**	**513**
Part Number:	**D4885-5P**	Revision:	**A**	
PO Number:	**PO23860**	Qty:	**1**	FAI No.

Item	Dimension	Measurement Inspected by: Rene Tougas, Q.C.	Remarks
33	.670+.000/-.001	.6697	
34	1.41	1.410	
35	R.031	.031	
36	1.10 REF	1.099	
37	Ø.86	.859	
38	24º	24º	Section Q-Q
39	Ø.125 thru	.125	
40	36º	36º	Section S-S
41	Ø.125 thru	.125	
42	Material:	17-4SS H900 2.00" RD BAR	Supplied by Customer
43	Treatment:	Liquid Penetrant	PO#: 20140224

skyservice Work Order Traveler

Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO21208	**Customer:** ATG Industries Inc	**Dept:** NDT YUL	**Reference:** 20140224
Descr:	**PN:**	**S/N:**	**Qty:** 1
Make:	**Model:**	**Reg:**	**A/C S/N:**
TSN: 0	**CSN:** 0	**TSO:** 0	

Task: UNSCHEDULED — **Sequence:** 1

Work Required:

CARRY OUT NDT ON 55 PARTS AS PER PO : 20140224

Action Taken:	Date:	Initial/Stamp:
LPI C/O AS PER ASTM E-1417M-13 NO CRACK FOUND PEN.(ZL-37 , B#10A070), CLEAN(SKC-S,B#09F21K),DEV.(SKD-S2,B#09L04K) EMU.(ZR-10B,B#10A074). DAS 27 ~~9~~-89 14/06/23	JUN 17 2014	DOT - APP 20 53-89

Description	*Location*	*P/N*	*Qty*	*Batch*	*S/N Off*	*S/N On*

COPY

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	**ACA/SCA Stamp** DOT - APP 20 53-89	Date: JUN 17 2014
Name: RAFIK MELIKIAN		